Item ID: D3272-1 Accept *NIOOOAAAA Setup Str	art *NS1*
Item ID: D3272-1 Revision ID: Item Name: Step Accept *N900040100* Setup Step St	^{op} *NS2*
Start Date: 03/11/2011 Start Qty: 10.00 *10* Required Date: 01/12/2011 Req'd Qty: 10.00 *10* Cust Item ID: Customer: Reference:	14()/
Approvals: Process Plan: M. C. 5 Date: 1\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	*NR1* *NR2*
Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Work Center ID Description Run Hours Code Qty Qty	Reject Insp. Number Stamp
Draw Nbr Revision Nbr	
D3272 Rev B	
100 0.00 *100* Large Fab Memo 0.00 **SQUARE ONE END BEFORE CUTTING OTHER END***	
1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A	
2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Deburr	
110 QC6- Inspect dimensions to drawing 0.00 *110* QC Memo 0.00 QC6- Inspect dimensions to drawing 0.00	·

Quality Control

W/O:	<u> </u>		wc	ORK ORDER CHANG	FS							
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		-										
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _				
	Res	solution:	Disposition	າ:	QA: N/C CI	osed:		Date: _				
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section		Verific	ation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C	Chief Eng	QC Inspector			
		The second secon										

•	November-03-11 10:40:54 AM			*/60)41*					Page 2
Item ID: Revision ID: Item Name:	D3272-1 Step			Accept	*N90004010) *	Setup S	Start Stop		S1* S2*
Start Date: Required Date Reference:	03/11/2011	Start Qty: 10.00 Req'd Qty: 10.00	*1 0 * *1 0 *		Cust Item ID: Customer:				TN.	5 /
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Date:]		Start Stop	*NI *N	R1* R2*
Sequence ID/ Work Center 120 *120* Packaging Packaging	ID	Operation Description Identify as per dwg & Sto	ck Location: WW	Set Up/ Run Hours 0.00	Tool ID Tool # Plan Code	Accept Qty	Qty	N	Reject Number	Insp. Stamp
130 *130* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00				N,	111/11	4 1

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W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CI	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes No DQA: Date:								
	Re	esolution:	Disposi	ion:	_ QA: N/C C	osed:		Date: _					
NCR:		V	WORK OR	DER NON-CONFORMA	ANCE (NCF	?)	• "						
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign 8	yerification Section C		Approval Chief Eng	Approval QC Inspector				
			Chief Eng	Chief Eng	Date	0000		Othor Eng	QQ moposion				
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Picklist Print

November-03-11 10:40:58 AM

Work Order ID: 76041

76041

Parent Item:

D3272-1

D3272-1

Parent Item Name: Step

Start Date: 03/11/2011

Required Date: 01/12/2011

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A

New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	58.0200	1	10			
D2622-1	200								**	14	1.11.9	Par .	

Step Extrusion

Location		Loc Oty	Loc Code	
HALL		48.32		
64	409	6		
683	293	0.5		
72	131	41.82		_/O
WA		9.7		
469	910	2		
669	970	7.7		

	=									
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1		
Part No	•	PAR #:	Fault Cate	gory:	NCR: Y	es N	o DQ /	A :	Date:	·
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NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (N	CR)				
DATE	STED	Description of NC	ļ.,,	Corrective Action Section B			Verific		Approval	Approval
DAIL	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng		Section C		on C	Chief Eng	QC Inspector
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DESIG	"P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANV	
CHECK	SED	APPROVED	DRAWING NO.	REV. B
(E	#	D3272	SHEET 1 OF 3
DATE			TITLE	SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

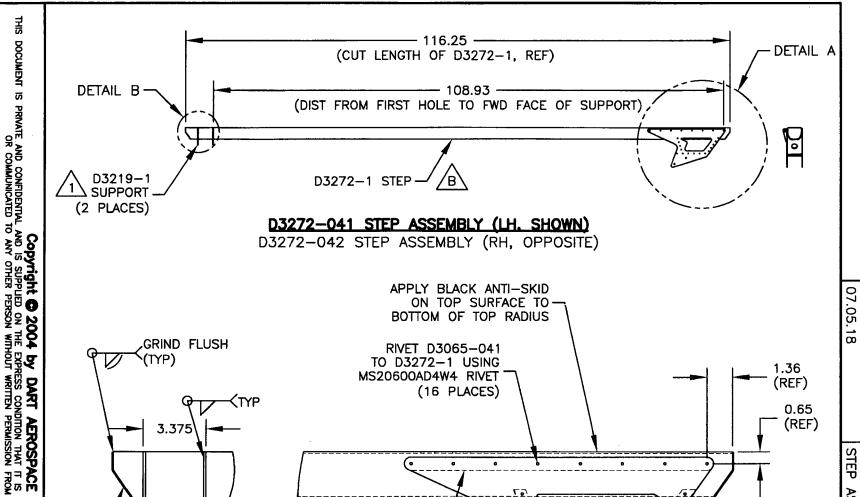
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	Res	olution:	Disposition	1:	QA: N/	C Clo	sed:		Date:		
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DATE	STEP	Description of NC						Approval	Approval		
DAIL	SIEF	Section A	Initial Action Description Chief Eng Chief Eng		tion Sign & Date				Chief Eng	QC Inspector	

SHEET

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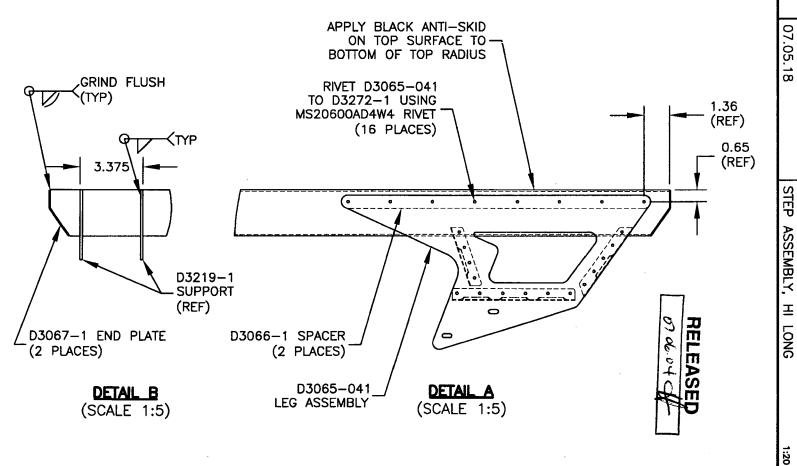
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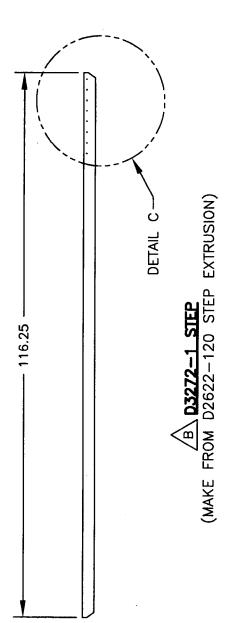


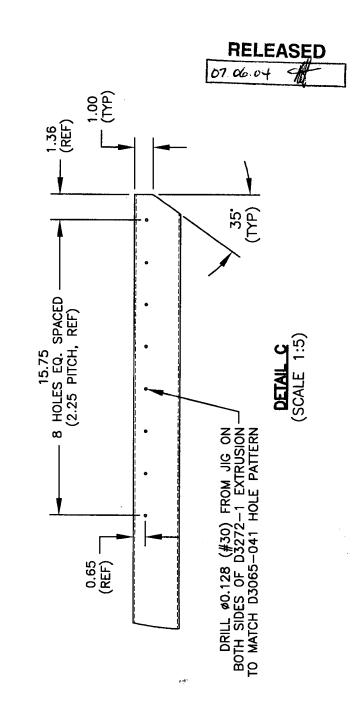
W/O:			W	ORK ORDER CHANG	ES				4	
DATE	STEP	PRO	OCEDURE CHA	ANGE	·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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	R	esolution:	Disposition	_ QA: I	N/C Clos	sed:		Date:		
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)				
DATE	CTED	Description of NC	Initial		ion B		Verification		Approval	Approval
DATE	SIEP	STEP Description of NC Section A		Action Description Chief Eng	tion Sign & Date			on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3272 SHEET 3 OF 3 DATE TITLE SCALE 07.05.18 STEP ASSEMBLY, HI LONG 1:20





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Dart Aerospac	e Ltd
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W/O:		WORK ORDER CHANGES									
DATE	STEP	PR	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				4			آنٍ				
Part No:		PAR #:	Fault Ca	itegory:	NCR: Yes	No DQ	A:				
Resolution:			Disposit	tion:	QA: N/C (QA: N/C Closed:			Date:		
NCR:		,	WORK OR	DER NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC		Corrective Action Section B			cation	n Approval Ap	Approval		
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NOTE: Date & initial all entries

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